



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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RBEM673V4001101
Job Sheet 182783



Part No: RBEM673V4001101

Job Qty: 1 ea

Part Name: Tail Servo Control Torque



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/31/18

Job Tracking No:

Due Date: 9/6/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM673V4001101 Rev. 2 IPP Rev. A 18.06.25 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/6/18	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs		9/6/18	0.00	0.20	Small Fab-4		MLC
120	QC	1 pcs		9/6/18	0.00	0.00	QC4		SMB
130	Packaging	1 pcs		9/6/18	0.00	0.00	Packaging3-1		MLC
140	QC21-FG	1 Ea		9/6/18	0.00	0.00	QC21		OCT 17 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Fabricate lanyard and attach Dart placard RB41011 into Descriptions: Pelican case APP-1060-E 3-Glue placard RBEM673V4001101-9 to RBEM673V4001101-19 foam as per DWG. 4-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	90-Start up Operation	5038398
APP-1060-E	Case	1 pcs (1 ea)	90-Start up Operation	5101779
CL-2-C	Lanyard Wire	.4160 ft (.416 ea)	90-Start up Operation	5093863
RBEM673V4001101-17	Bottom Foam use in case APP-1060-E	1 Ea (1 ea)	90-Start up Operation	5101777
RBEM673V4001101-19	Top Foam use in case APP-1060-E	1 Ea (1 ea)	90-Start up Operation	5101778
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	502040
RBEM673V4001101-1	Short Ring End Assembly	1 Ea (1 ea)	110-Small Fab	5118989
RBEM673V4001101-13	1/2" Drive Offset Adapter	1 Ea (1 ea)	110-Small Fab	5109333
RBEM673V4001101-5	Long Ring End Assembly	1 Ea (1 ea)	110-Small Fab	5118991
RBEM673V4001101-9	Contents Placard	1 Ea (1 ea)	110-Small Fab	5108080

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	3896T31	2	839	0
	APP-1060-E	1	5	0
	CL-2-C	0	387	0
	RBEM673V4001101-17	1	1	0
	RBEM673V4001101-19	1	1	0
	RB41011	1	792	0
110-Small Fab	RBEM673V4001101-1	1	0	0
	RBEM673V4001101-13	1	0	0
	RBEM673V4001101-5	1	0	0
	RBEM673V4001101-9	1	0	0



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Container No: S118994



Part: RBEM673V4001101

Job No: 182783

Serial No/Batch: S118994

Revision: 2

Inspector:

Exp Date:

Instructions:

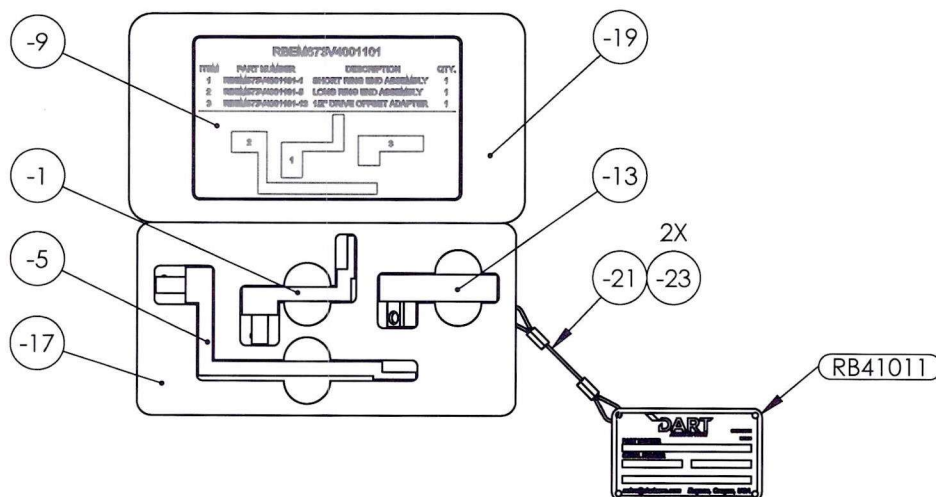
Date: 10/16/18

Part Specifications
Specifications could not be found.

Plex 8/31/18 3:15 PM dart.logan.david

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	5/13/2016	DPD	JAG
2	17-0008	-3 CH'D ENGRAVE NOTE WAS "RBEM673V4001101-3" IS "RBEM673V4001101-1". -7 CORRECTED SPELLING WAS TORQUE IS TORQUE. -17 & -19 CH'D MATERIAL & VENDOR WAS Y20, BLACK (I.R. SPECIALTY) IS ETHAFOAM 220, BLACK (CASE SOLUTIONS). -17 DELETED DIM 4X R.19, ADDED DIM 4X 45°, 4X .50. -19 DELETED DIM 4X R.25, ADDED DIM 4X 30°, 4X .75. -21 & -23 ADDED.	4/14/2017	RJC	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	SHORT RING END ASSEMBLY			2
	1		-3		SHORT RING END	4140/4142		3
X			-5	1	LONG RING END ASSEMBLY			4
1			-7		LONG RING END	4140/4142		5
			-9	1	CONTENTS PLACARD	PLASTIC		6
1	1	B/O	-11		PLUNGER	S.S.	Ø.12 NOSE X Ø.157 BODY X .23 OAL (MCMASTER-CARR #84895A71)	2 & 4
		B/O	-13	1	1/2" DRIVE OFFSET ADAPTER	STEEL	1/2" DRIVE OFFSET ADAPTER (FACOM #S.234, ULTIMATE GARAGE #S.234)	1
		B/O	-15	1	CASE	PLASTIC	PELICAN #APP-1060-E	N/S
		B/O	-17	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	1.40 X 4.19 X 8.19 (CASE SOLUTIONS)	7
		B/O	-19	1	TOP FOAM CUSHION	ETHAFOAM 220, BLACK	.83 X 4.56 X 8.56 (CASE SOLUTIONS)	8
		B/O	-21	1	LANYARD	COATED STEEL	Ø1/16 X 3 (CARR LANE #CL-2-C)	1
		B/O	-23	2	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1
		B/O		1	PLACARD	ALUMINUM	RB41011	1
ASSY -5	ASSY -1							

NOTE:
REF. AIRBUS T/N: M673V4001101.



TITLE
TAIL SERVO CONTROL TORQUE WRENCH

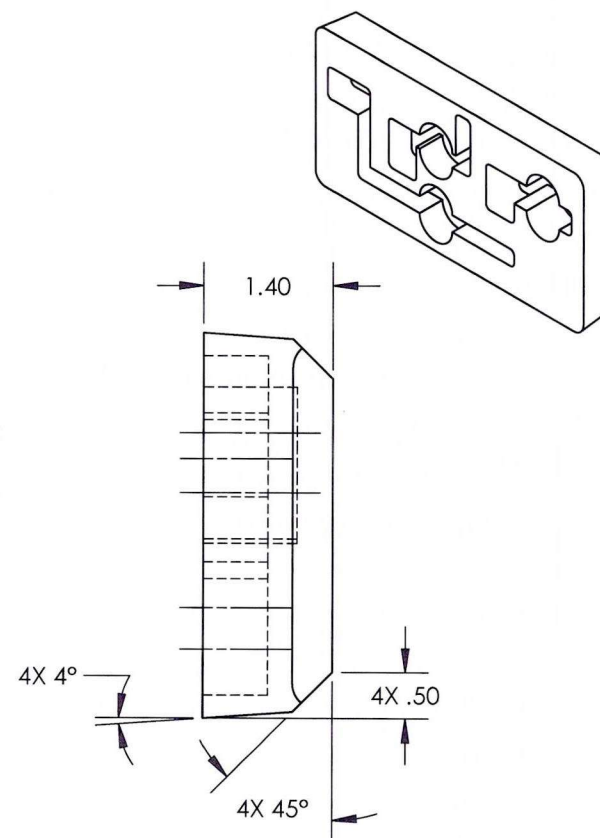
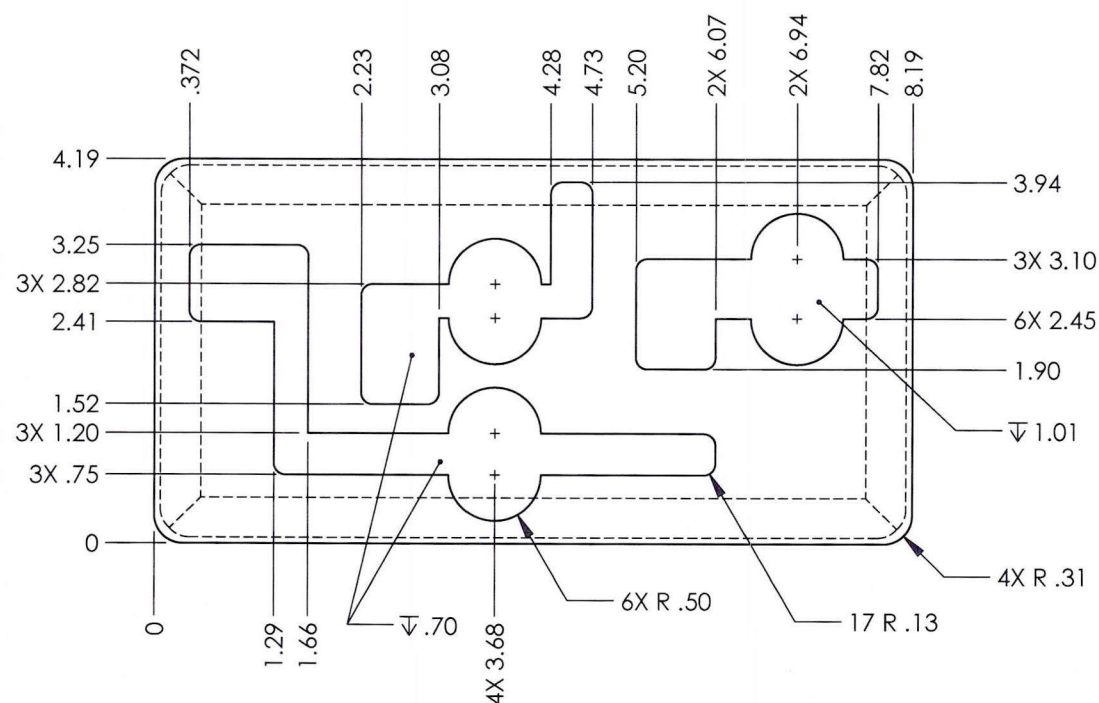
DWG NO. RBEM673V4001101

REV 2

MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:4	DATE 3/2/2016
	SHEET 1 OF 8

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	17-0008	-17 DELETED DIM 4X R.19, ADDED DIM 4X 45°, 4X .50, CH'D MATERIAL & VENDOR WAS Y20, BLACK (I.R. SPECIALTY) IS ETHAFOAM 220, BLACK (CASE SOLUTIONS).	4/14/2017	RJC
				JAG

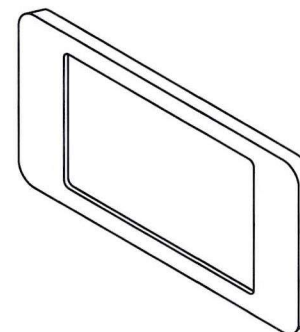
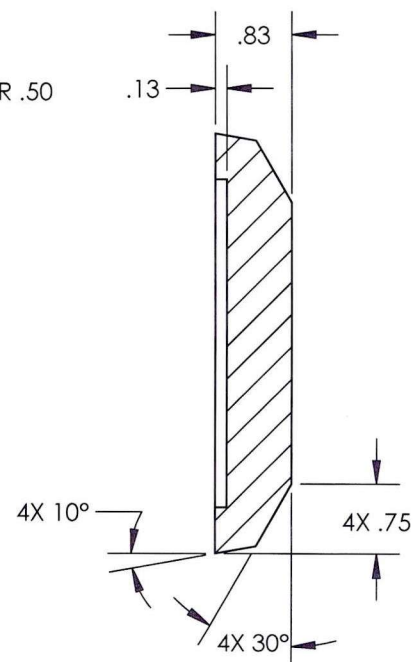
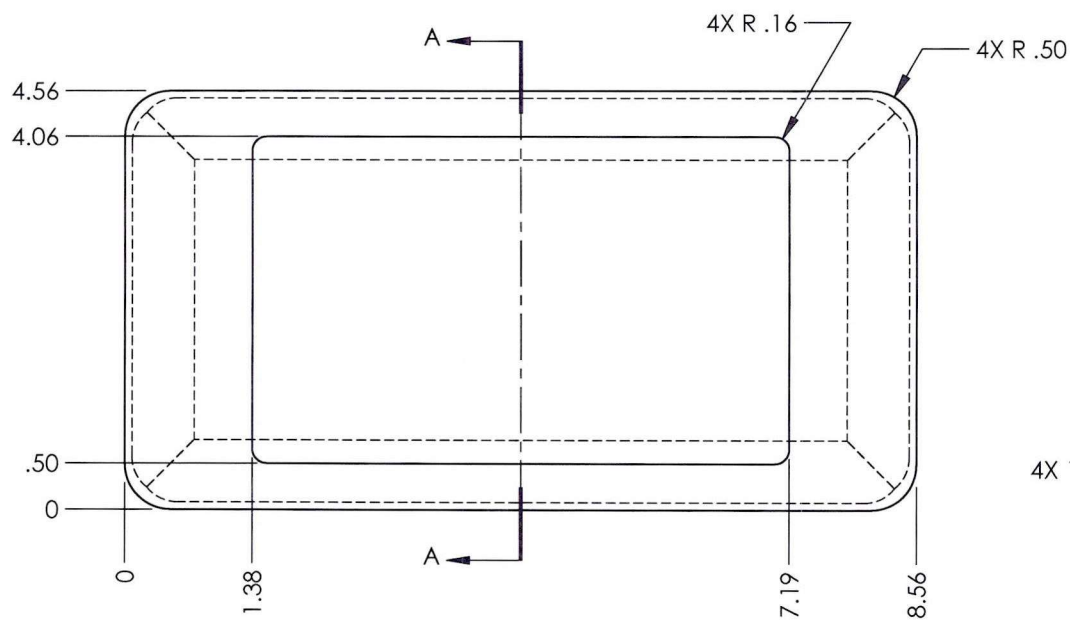


(-17)
BOTTOM FOAM

DART AEROSPACE	
TITLE TAIL SERVO CONTROL TORQUE WRENCH	
DWG NO. RBEM673V4001101-17	REV 2
MAT'L ETHAFOAM 220, BLACK	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	.X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 3/2/2016 SHEET 7 OF 8

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0008	-19 DELETED DIM 4X R.25, ADDED DIM 4X 30°, 4X .75, CH'D MATERIAL & VENDOR WAS Y20, BLACK (L.R. SPECIALTY) IS ETHAFOAM 220, BLACK (CASE SOLUTIONS).	4/14/2017	RJC	JAG



SECTION A-A

-19
TOP FOAM CUSHION

DART AEROSPACE	
TITLE TAIL SERVO CONTROL TORQUE WRENCH	
DWG NO. RBEM673V4001101-19	REV 2
MAT'L ETHAFOAM 220, BLACK	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	.X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H175
APPROVED: GILBERT	
SCALE 1:2	DATE 3/2/2016 SHEET 8 OF 8